

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008066**Date Inspected:** 29-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Ma Yun, Chen Ying Xin.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

North Tower Lift 3 Corner Seam Skin D/E

FCAW welding of weld joint 85A located on NSTL3-3B/K.

Welder is identified as 040533. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-Tc-U4b-F.

North Tower Lift 3 Corner Seam Skin C/D

FCAW welding of weld joint 81A located on NSTL3-3B/K.

Welder is identified as 040343. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-U4b-F.

North Tower Lift 3 Corner Seam Skin B/C

SAW welding of weld joint 82B located on NSTL3-3B/K.

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Welder is identified as 052917. ZPMC QC is identified as Mr. Wang Chuan Qin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-C-U2b-S-2.

North Tower Lift 3 Corner Seam Skin A/B

FCAW welding of weld joint 83B located on NSTL3-3B/K.

Welder is identified as 040261. ZPMC QC is identified as Mr. Wang Chuan Qin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U4b-F.

SAW welding of weld joint 83B located on NSTL3-3B/K.

Welder is identified as 201750. ZPMC QC is identified as Jiang La Mei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

South Tower Lift 4 Skin E Doubler Plate

FCAW welding of weld joint 3 located on SSD1-FESA4-1E/E.

Welder is identified as 066397. ZPMC QC is identified as Mr. Wan Wen Zhong.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P4-F.

FCAW welding of weld joint 12 located on SSD1-FESA4-1D/F.

Welder is identified as 067954. ZPMC QC is identified as Mr. Yuan Hui Gang.

The welding variables recorded by QC appeared to comply with WPS-B-T-4332-Tc-P4-F.

North Tower Lift 1 Corner Seam Skin A/E (WRR No. T-WR1668)

FCAW welding of weld joint 4A/B (Repair) located on NSD1-A112B/H.

Welder is identified as 053474. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G-REPAIR.

South Tower Lift 2 Skin C of Interior Connection Plate (WRR No. T-WR1853)

This QA inspector observed the surface welding to the interior connection plate of skin C in 50.3M in the south tower stiffener in the 2nd lift, which has insufficient size from one end to the machined size. FCAW welding located on SSD1-SA106, welders are identified as 070217 and 066695. ZPMC CWI is identified as Mr. Li Ming and the welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-Repair. 15mm surface welding is needed, including the skin plate and stiffener as per the welding repair report. For more details please refer to the attached pictures.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod : 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
